

Date: Monday, 1/8/2007 10:50:08 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ACCESS PANEL ASSEMBLY  
 Job Number : 30149  
 Estimate Number : 12546  
 P.O. Number : *NIA*  
 This Issue : 1/8/2007 S.O. No. : *NIA*  
 Prsht Rev. : NC  
 First Issue : *NIA* Type : SMALL /MED.FAB  
 Previous Run : *NIA*  
 Part Number : D3256041  
 Drawing Number : D3256 REV A'B  
 Project Number : N/A  
 Drawing Revision : *KB*  
 Material : *NIA*  
 Due Date : 1/14/2007 Qty: 4 Um: Each  
 Written By : *07.01.08*  
 Checked & Approved By : *07.01.08*  
 Comment : Est Rev:A New Issue 06-10-03 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S22GA 304/316 .032 Sheet



Comment: Qty.: 0.9870 sf(s)/Unit Total: 3.9480 sf(s)  
 304/316 .032 Sheet  
 Batch: *M102159*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3256  
 Dwg Rev: *B*  
 Prog Rev: *B*

2-Deburr if necessary

*SAD 07/01/27* (4)  
*SAD 07/07/12*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/01/27* (4)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*07/01/29* (4)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE Form using D3256-1T2

*FF 07-02-204*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PP Date: 07/05/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:50:08 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 30149

Part Number: D3256041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1/07/04/16 (4)

7.0

D32563

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Gasket

Batch: 30302

FF 07-04-26 4

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install D3256-3 gasket using 3M Scotch-grip adhesive as per Dwg D3256

A/R 1300/1300L 3M Adhesive Batch: 17102890

2-AFTER CURING, transfer holes from D3256-1 into D3256-3.

FF 07-05-01 4  
FF 07-04-26 4

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/01 (4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/05/01

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/02 (4)

Job Completion



U 07/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

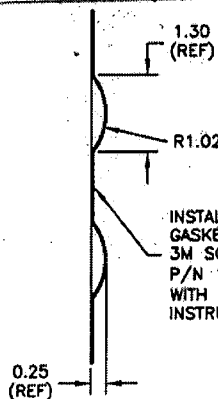
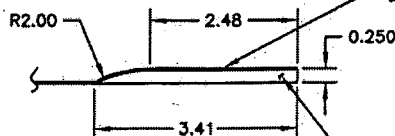
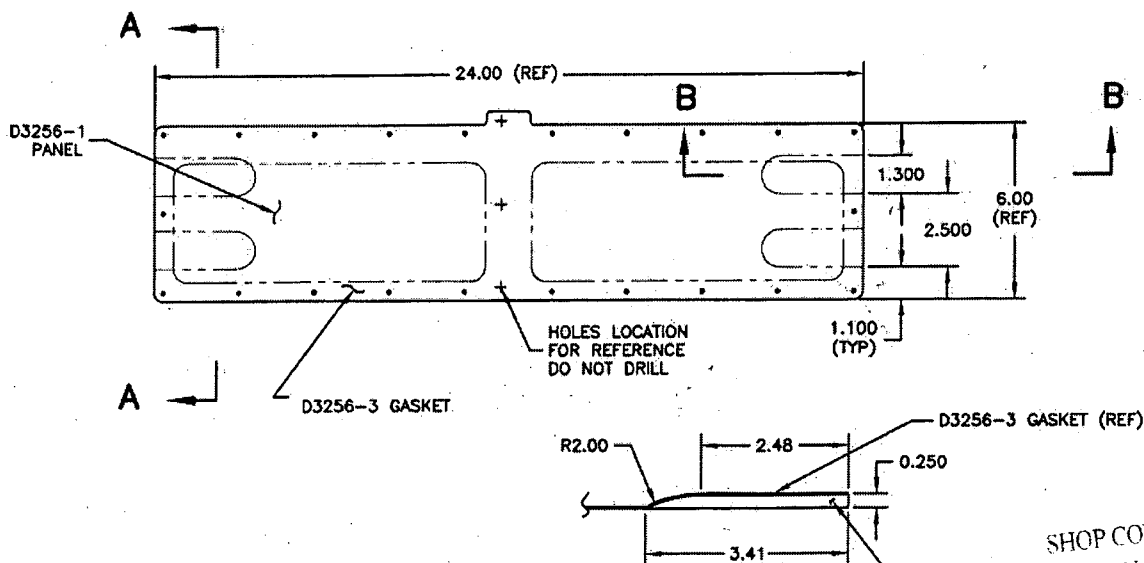
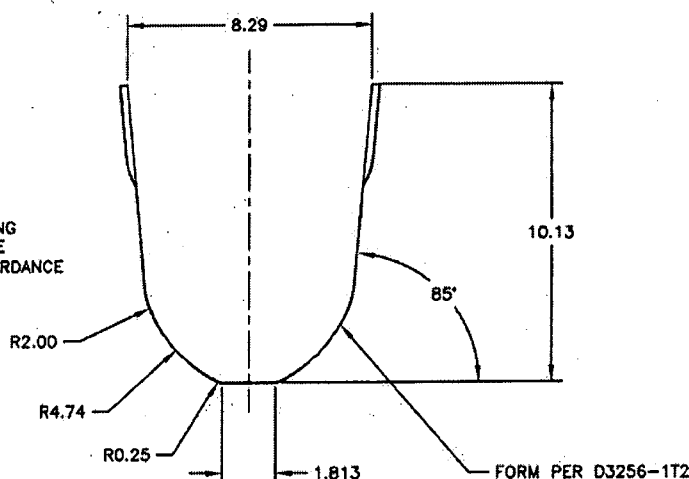
NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3256	REV. B SHEET 1 OF 3
DATE 05.06.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	05.06.27	D3256-3 DIM 1.30 WAS 0.65	

**RELEASED**

05.06.30

**VIEW A-A  
SCALE 1:3****VIEW B-B  
SCALE 1:3**

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 30149

**D3256-041 ACCESS PANEL ASSEMBLY**

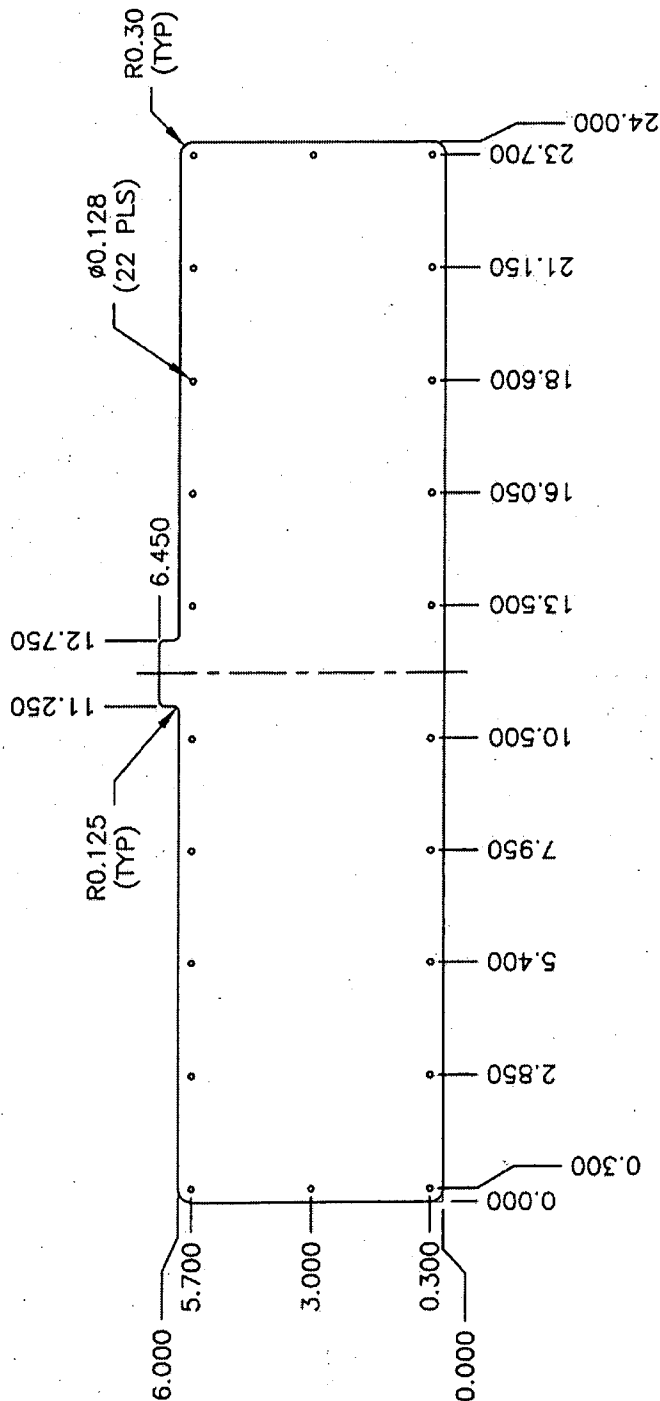
1) IDENTIFY WITH P/N &amp; B/N USING FINE POINT PERMANENT MARKER

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CHECKED 	APPROVED 	DRAWING NO. D3256	REV. B SHEET 2 OF 3
DATE 05.06.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

**D3256-1 FLAT PATTERN****D3256-1 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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RETURN TO  
ENGINEERING

**RELEASED**

05-06-30

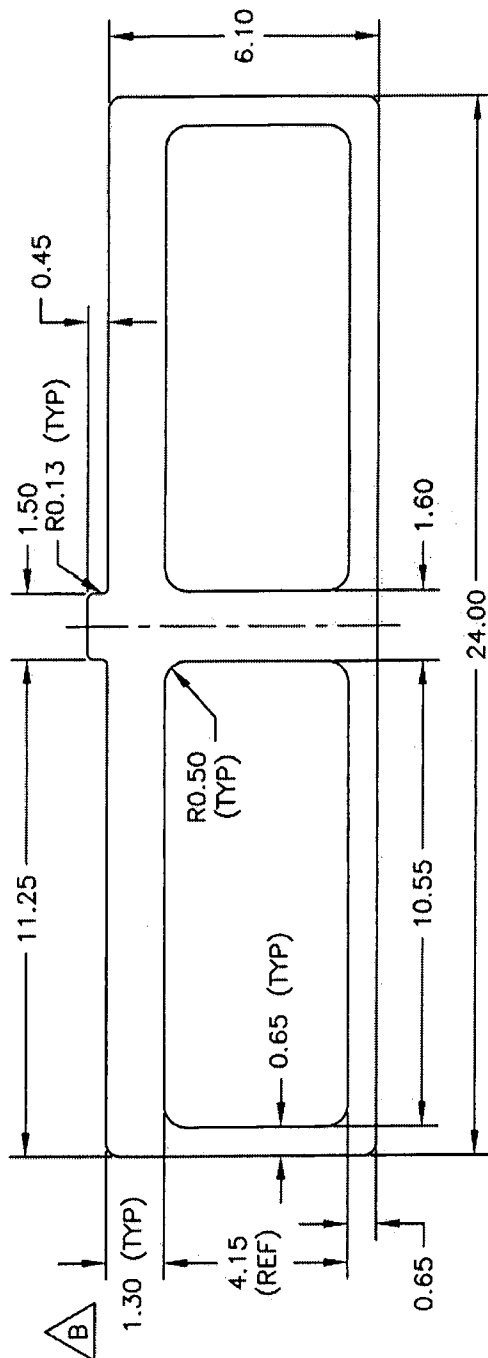
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WORK ORDER  
NO. 30149

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3256	REV. B SHEET 3 OF 3
DATE 05.06.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4



RELEASED

05.06.30 *[Signature]*

D3256-3 GASKET

D3256-3 NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET 0.035 THICK  
MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2)  
OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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NO. 30149

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DART AEROSPACE LTD		Work Order: 30149
Description:		Part Number: D32 56-041
Inspection Dwg:	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.000	$\pm 0.010$	6.007	✓		Vern	
2.850	$\pm 0.010$	2.854	✓		Vern	
5.400	$\pm 0.010$	5.404	✓		Vern	
7.950	$\pm 0.010$	7.957	✓		<del>Vern</del> Vern	
10.500	$\pm 0.010$	10.496	✓		Vern	
13.500	$\pm 0.010$	13.500	✓		measuring tape	
16.050	$\pm 0.010$	16.050	✓		measuring tape	
18.600	$\pm 0.010$	18.600	✓		measuring tape	
21.150	$\pm 0.010$	21.150	✓		measuring tape	
23.700	$\pm 0.010$	23.700	✓		measuring tape	
24.00	$\pm 0.010$	24.000	✓		measuring tape	
0.032	$\pm 0.010$	0.031	✓		Vern	
3.000	$\pm 0.010$	3.007	✓		Vern	
0.300	$\pm 0.010$	0.297	✓		Vern	
6.450	$\pm 0.010$	6.456	✓		Vern	
11.250	$\pm 0.010$	11.250	✓		Vertical Vern	
12.750	$\pm 0.010$	12.750	✓		vertical Vern	
Ø 0.128	$\pm 0.005$	Ø 0.130	✓		Vern	

Measured by: SAD	Audited by:	Prototype Approval:
Date: 07/01/27	Date: 07/01/29	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	